



Dart Aerospace Ltd.
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Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

646.3510

Job Sheet 174102



Part No: 646.3510

Job Qty: 10 ea

Part Name: Strut



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 3/9/18

Job Tracking No:

Created By: Michelle Gagnon-Donovan

Due Date: 3/23/18

Description:

Type: **SOLD**

Note: DWG REV N/C 3 IPP REV:A 12.10.19 NEW ISSUE DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	10 Ea	3/22/18	3/22/18	0.00	0.00	Start Up Waterjet		mc 18/03/12
110	Waterjet	10 pcs	3/22/18	3/22/18	0.00	0.39	Waterjet1		mc 18/03/12
120	QC	10 pcs	3/22/18	3/22/18	0.00	0.00	QC2 Waterjet-1		mc 18/03/12
130	QC	10 pcs	3/22/18	3/22/18	0.00	0.00	QC8-1		38
140	Small Fab	10 pcs	3/22/18	3/22/18	0.03	4.12	Small Fab-1		DYC 9-89 18/03/15
150	QC	10 pcs	3/22/18	3/22/18	0.00	0.00	QC5		FL
160	Large Fab	10 pcs	3/22/18	3/22/18	0.00	11.76	Large Fab 1		DYC 18/03/15
170	QC	10 pcs	3/22/18	3/22/18	0.00	0.00	QC9		PD 18-3-23
180	QC	10 pcs	3/22/18	3/22/18	0.00	0.00	QC5		PD 18-3-23
220	SprayPaint	10 pcs	3/23/18	3/23/18	0.00	0.37	Spray Paint		APR 04 2018
230	QC	10 pcs	3/23/18	3/23/18	0.00	0.00	QC14		11 APR 04 2018
240	Packaging	10 pcs	3/23/18	3/23/18	0.00	0.00	Packaging3-1		9-89
250	QC21-SA	10 Ea	3/23/18	3/23/18	0.00	0.00	QC21		DAS 21 9-89 APR 05 2018

Part Op 110 - 1-Cut 646.3500 plate 2.75"x 1.50" as per Dwg Prog Rev: _____ 2-Deburr if necessary

Descriptions: 140 - 1- Fabricate tube as per dwg USE DT10290 PUNCH

160 - Weld tube to plate as per dwg. DT9867 Weld end were tube is punch.

220 - Prime as per dwg (see note 3) Batch: 138747

240 - ***IDENTIFY AS PER APICAL MPP-120 BY STAMPING THE P# AND REV***

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M304S16GA	304/316 Sheet .063	.2780 sf (.0278 ea)	90-Start up Operation	
M304TR0.500W.049	304 Round Tube .500 X .049W	8.3300 ft (.833 ea)	140-Small Fab	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M304S16GA	0	282	0
140-Small Fab	M304TR0.500W.049	8	202	0



Container No: S050453

Part: 646.3510

Job No: 174102

Serial No/Batch: S050453

Revision:
Inspector:

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Date: 03/12/18

Part Specifications					
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Strut	2.750Inches $\pm$ 0.030	2.780 2.720		
2	Strut	1.500Inches $\pm$ 0.030	1.530 1.470		
3	Strut	0.063Inches $\pm$ 0.010	0.073 0.053		

Plex 3/9/18 4:15 PM Dart.Gagnon.Michelle